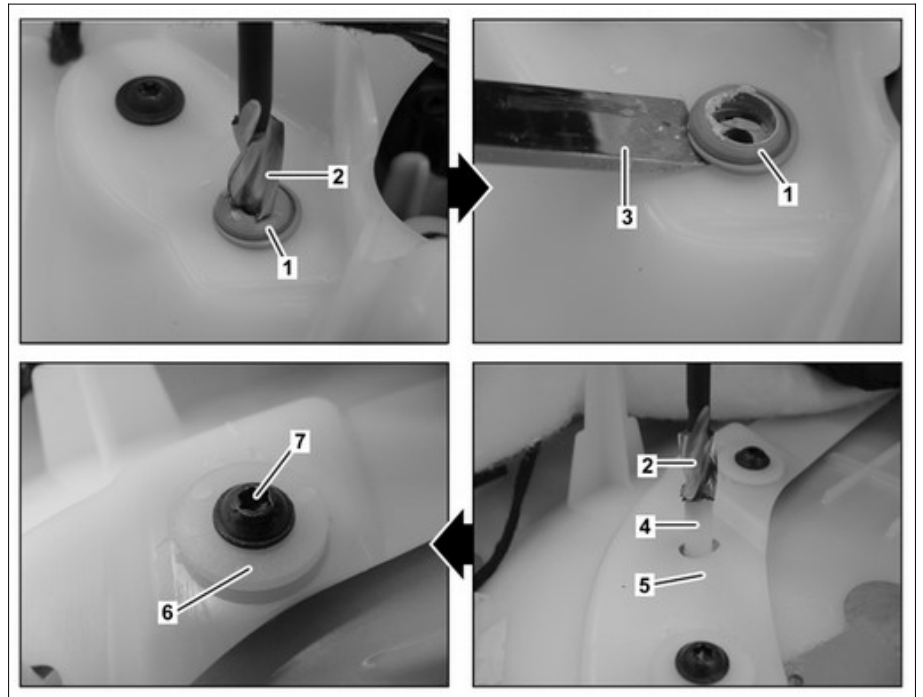


AR72.00-P-0001-01LW	Remove/install plastic-welded component parts of door trim		
---------------------	--	--	--

Model 166, 167, 172, 176, 192, 205, 206, 213, 214, 217, 218, 222, 223, 232, 238, 246, 253, 254, 257, 290, 292, 294, 295, 296, 297



P72.00-2249-06

Remove

1 Drill the centering point of the plastic spot welds (1) with a drill bit.

i Drilling process with high revolution speed and low operating speed.

i Use a drill bit with a diameter of 3.5 mm.

2 Cut off plastic spot welds with a spot facer (2).

i Milling process with high revolution speed and low operating speed.

i Use a M5 spot facer (2) as per DIN 373.

3 Remove any remaining residues of the plastic spot welds (1) with the chisel (3).

i Use a chisel (3) as per DIN 5139 with a blade width of 10 mm.

4 Take off component .

Install

5 Position component part.

Only when installing a new component part.

6 Cut off mounting domes (4) of the component part inserted in the door trim with the spot facer (2) so that it is flush with the level of the contact surface (5).

7 Fasten component part with washers (6) and screws (7).